

Work Order ID 82662

\*82662\*

Page 1

April 04/12 1:52:40 PM

Item ID: D2803-2

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 04/04/2012 Start Qty: 6.00

\*6\*

Customer ID:

Required Date: 18/04/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/04 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Setup/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2803

Rev B

100

0.00

\*100\*

FLOW WATERJET

Waterjet

FLOW CNC Waterjet

Memo Blank

1-Cut as per File d2803-2

Dwg Rev:

Prog Rev:

2-Deburr if necessary

6061 BAR

500 x 10.00

110

0.00

\*110\*

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

HAAS CNC vertical machine #1

Machine as per folio FA102

120

QC2-Inspect parts off machine FA1/FAIB

0.00

\*120\*

QC

Memo

Quality Control

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82662

**\*82662\***

Page 2

April-04-12 1:52:40 PM

Item ID: D2803-2

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket

Start Date: 04/04/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/  
WorkCenter ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

**\*130\***

QC  
Quality Control

Memo

0.00

*OK 12/05/31*

*6*

*2*

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

Hand Finish  
Hand Finishing

Memo

0.00

*6*

*26 12-5-31*

145

QC7-Inspect Chemical Conversion Coat

0.00

**\*145\***

QC  
Quality Control

Memo

0.00

*6*

*PR 12-5-31*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**\*82662\***

Page 3

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 04/04/2012    **Start Qty:** 6.00    **\*6\***

**Cust Item ID:**

**Required Date:** 18/04/2012      **Req'd Qty:** 6.00      **\*6\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Accept  
Qty

Reject  
QtyReject  
Number

Insp.  
Starr

Identify as per dwg & Stock Location: C-A 0.00

0.00

**\*150\***

## Packaging

## Memo

0.00

## Packaging

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

## Memo

0.00

## Quality Control

12/6/68

MF - 12-06-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

April-04-12 1:52:44 PM

Page 1

Work Order ID: 82662

\*82662\*

Parent Item: D2803-2

\*D2803-2\*

Parent Item Name: Bracket

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A 00.11.06New IssueEC  
IPP Rev:B Blanks now cut on Waterjet 06-06-14 JLM  
IPP Rev:C Removed Tumbling 08-09-10 JLM Verified By:EC IPP  
Rev:D add qc3 DD 10.02.19 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X10.00 0		Purchased	No			100	f	22.5000	1.9167	12.10547			

\*M6061T6B0 500X10 000\*

\*\*

6061-T6 Bar .500 x 10.00

Location

Loc Qty

Loc Code

MAT004

22.5

120421

22.5

121660

121660

Jm / 5  
12-5-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order:	82662
Description: Bracket		Part Number:	D2803-2
Inspection Dwg: D2803 Rev: B		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	7.58	✓		FK-01	Mic
1.420	+/-0.001	1.420	✓		"	"
Ø0.191	+0.005/-0.000	.191	✓		FK-04	Vern.
Ø0.507	+0.000/-0.001	.5061	✓		FK-01	Mic
Ø0.507 x 0.250	+0.000/-0.001	.5062 x .245	✓		"	"
12.411	+/-0.010	12.411	✓		ENC-02	Vern.
6.933	+/-0.010	6.933	✓		"	"
0.250	+/-0.010	.250	✓		FK-04	Vern.
0.875	+0.000/-0.001	.8743	✓		FK-01	Mic.
0.250	+0.000/-0.005	.248	✓		FK-06	Dept Gauge
0.125	+/-0.010	.134	✓		FK-04	Vern
0.125	+/-0.010	.132	✓		"	"
0.500	+/-0.010	.502	✓		"	"
0.125	+/-0.010	.125	✓		"	"
0.188	+/-0.010	.188	✓		"	"
0.562	+/-0.010	.564	✓		"	"
0.125	+/-0.010	.134	✓		"	"

Measured by: FK	Audited by: [Signature]	Prototype Approval:	N/A
Date: 12/05/27	Date: 12/05/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.12.07	13.558 dimension removed	KJ/JLM	
C	08.01.16	Tolerance revised for 0.875 dimension	KJ/EC/DD	[Signature]

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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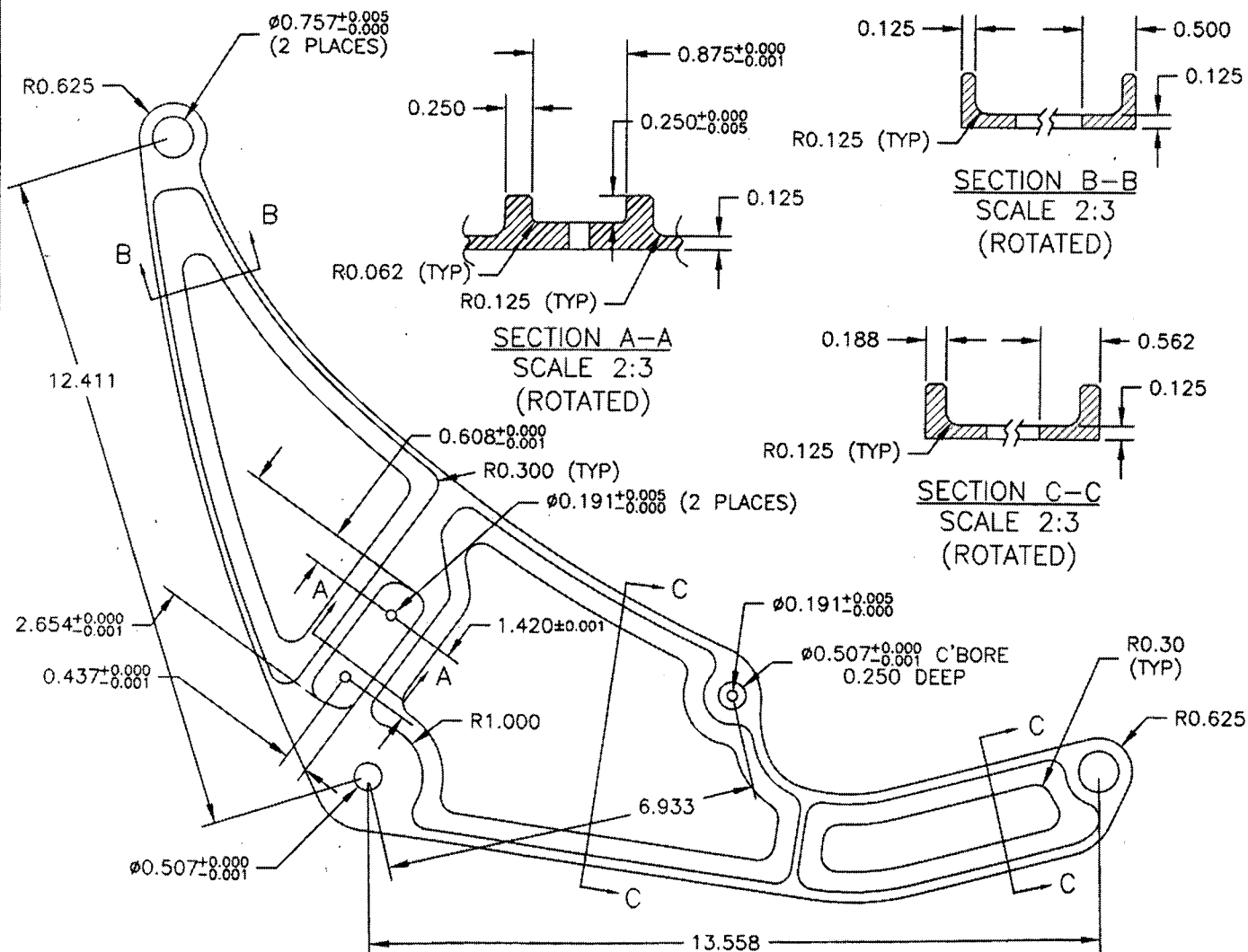
**NOTE:** Date & initial all entries

**DART**

RELEASED

05-03 11

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2803	SHEET 1 OF 2
DATE	04.11.22	TITLE	STA 84 BRACKET	SCALE	1:3
A	00.11.07	NEW ISSUE			
B	04.11.22	ADD CUTOUTS & -043/-044			

**D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 82662 MJS  
12/04/04

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

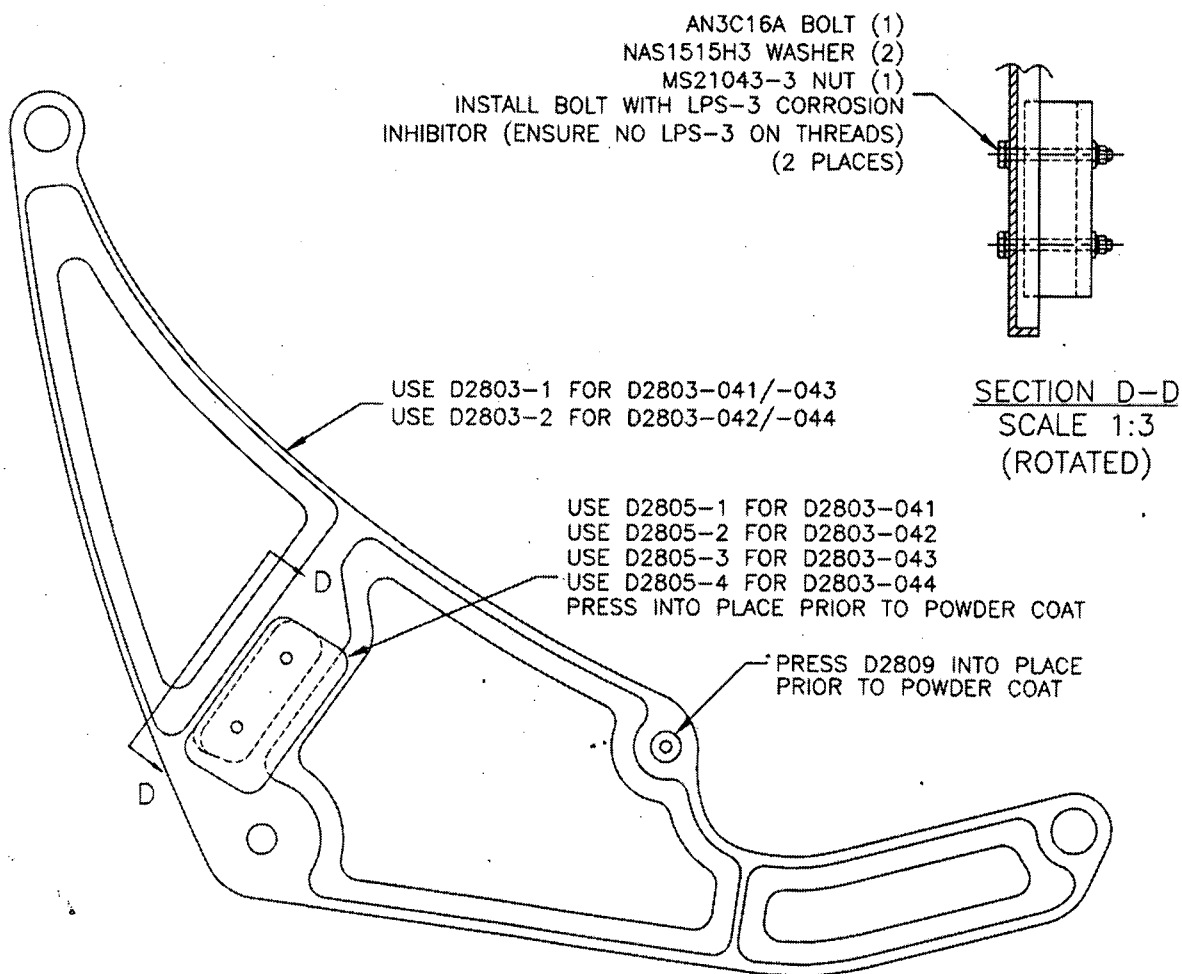
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**NOTE:** Date & initial all entries

**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE	04.11.22		TITLE	STA 84 BRACKET	
					SCALE 1:3

**RELEASED**05-03.11 *[Signature]**82602*

**D2803-041/-043 BRACKET ASS'Y (SHOWN).**  
**D2803-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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